

Split
Work Order ID 70459-1

Wednesday, June 08, 2011 7:44:44 PM

Item ID: D2574

Revision ID:

Item Name: Saddle, Aft In 205

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/24/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Program Batch No. 70459 Double check by: 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

SL 11/06/22 (2)

110



Mil Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

Machine keyway as per dwg D2573 & D2574

SL 11/06/22

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SL 11/06/22

~~70459-1~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70459

Wednesday, June 08, 2011 7:44:44 PM

Page 2

Item ID: D2574

Accept

Revision ID:

Item Name: Saddle, Aft In 205

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/24/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

Re 11-6-22

2

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

2 BL 11-6-22

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

2x Ø M-11/06/22

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:30

320°F

11:00

M116964

Work Order ID 70459

Wednesday, June 08, 2011 7:44:44 PM

Item ID: D2574

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Aft In 205

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/24/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 0 BL 11.6.22

170

Identify as per dwg & Stock Location: +34

0.00



Packaging

Memo

0.00

Packaging

11/6/22 20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22 20
MF
11-06-22

Picklist Print

Wednesday, June 08, 2011 7:44:40 PM

Page 1

Work Order ID: 70459

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205




Start Date: 6/16/2011

Required Date: 6/24/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: T As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			110	Each	63.0000	1	12		11/06/22	

Location	Loc Qty	Loc Code
MAT045	27	
66966	27	
MAT046	36	
65382	11	
65953	16	
66966	9	

DART AEROSPACE LTD		Work Order:	70459
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000			
F	0.490	0.510		.499	.500				
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.501	.501			
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.569	.568			
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125			
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.251			
S	0.115	0.135		.126	.127	.127			
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.239			
W	0.115	0.135		.123	.121				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363				
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626				
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.247			
AE	1.500	1.520		1.513	1.513	1.513			
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.240	.240	.240	.240		
AH	0.240	0.260		.250	.250	.250			
AI	2.000	2.020		2.003	2.003	2.003			
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	.SL
Date:	11/06/21

Audited by:	RF
Date:	11-6-22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: C.

H:\FORMS\Quality Assurance

H:\FORMS\Quality Assurance\Approved QA\NCRWO RevE

